

Split SB 07/06/05

Date: 5/25/2007 8:37:41 AM

Ken Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32661-9
 Estimate Number : 12811
 P.O. Number :
 This Issue : 5/25/2007 S.O. No. :
 Pmt Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 32003
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue: 07-03-26 ec

Drawing Name : BRACKET
 Part Number : D35921
 Drawing Number : D3592 REV A
 Project Number : N/A
 Drawing Revision : REV A
 Material :
 Due Date : 6/10/2007

UNDER REVIEW

07-06-04

OK 125 07/06/05

Qty: 125 Um: Each

20

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M5061T6S125	6061-T6 .125 Sheet
		Comment: Qty.: 0.1460 sf(s)/Unit Total : 17.5140 sf(s) 6061-T6 .125 Sheet Batch: M104366 M104366 ***Grain must be Along 4.63*****
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3592 Dwg Rev: # Prog Rev: #
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

SB 07/06/06 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/05	5	Split W/O		SB	07/06/05	30		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

At: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



20706-06 (20)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W.A. (Steps)

POSITIVE RECALL

EFFECTIVE 07.06.07 AUTH uRELEASED 07.06.07 DATE u

20706-06 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Completion



u 07.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

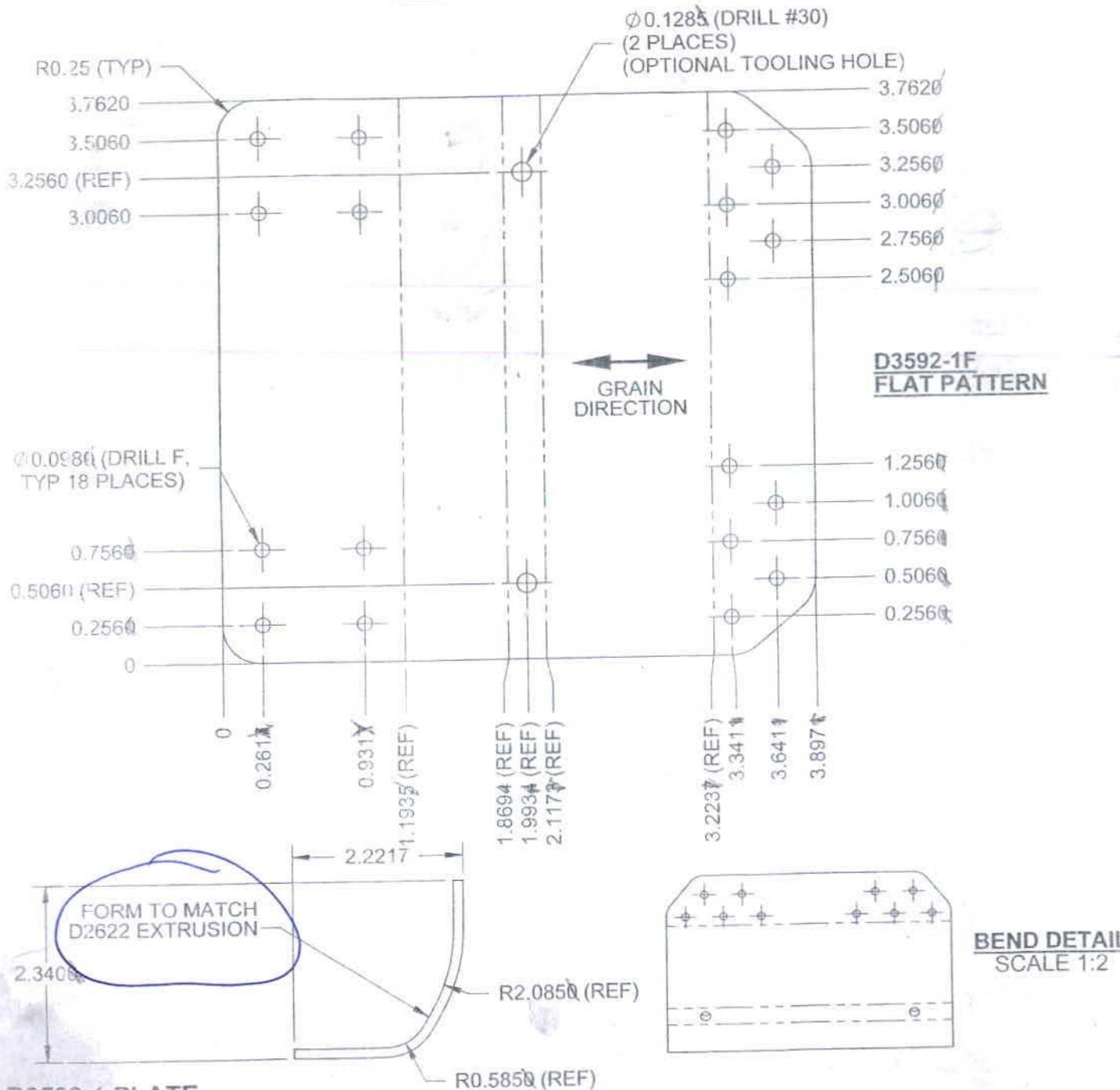
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

100th ANNIVERSARY ISSUE
1907-2007

DESIGN <i>9P</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D3592	<i>R.B.</i>	REV. A SHEET 1 OF 1
DATE 07.01.15	TITLE PLATE		SCALE 1:1	
A	07.01.15	NEW ISSUE		
B	07.05.31	TOOLING HOLES ADDED		



D3592-1 PLATE

NOTES:

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS 0.010 MAX

AEROSPACE LTD

Work Order: 32661

Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.128	+0.005 -0.001	0.129	✓		VERN	
20.092	+0.004 -0.001	0.099	✓		VERN	
2.506	+/-0.010	0.510	✓		VERN	
2.256	+/-0.010	0.260	✓		VERN	
2.756	+/-0.010	0.760	✓		VERN	
2.56	+/-0.015	3.260	✓		VERN	
	+/-0.010	0.265	✓		VERN	
1.0	+/-0.010	1.995	✓		VERN	
	+/-0.010	3.346	✓		VERN	
C3	0.0	3.645	✓		VERN	
	3.902	✓			VERN	
	766	✓			VERN	

20 Wk

Comment: FLOW

1-Cut a

Dwg Rev

Prog Rev:

2-Deburr if ne.

3.0 QC2



Comment: INSPECT PARTS AS

4.0 QCB



Comment: SECOND CHECK

5.0 SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOUR

Prototype Approval: N/A

Date: N/A

Revised by KJ/RF Approved



NOTE: Date & initial all entries

